

Date: Tuesday, 20/05/2008 11:40:18 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LID PRO ARM ASSEMBLY (SHORT)
Job Number :	39332		
Estimate Number :	10258		
P.O. Number :		Part Number :	D2332041
This Issue :	20/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2332
First Issue :	1 / 1	Project Number :	N/A
Previous Run :	38797	Drawing Revision :	
	Type :	Material :	
	SMALL / MED FAB	Due Date :	27/05/2008
Written By :		Qty:	20
Checked & Approved By :	<i>mf</i>	Um:	Each
Comment :	Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5KJ/ RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR1000W049	304 RD Tube 1.0" x .049W
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Comment: Qty.: 0.4331 f(s)/Unit Total : 8.6625 f(s)
 Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

Batch *M107950*

Batch

EB08/05/22

2.0	M304R250	1/4" 304 SS Roundbar
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Comment: Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s)
 Material: Ø0.250" 304SS Rod

Batch *M107387*

EB08/05/22

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Debur

3 *EB08/05/22* *(20)*

4.0	M304TR0500W035	304 RD Tube .500 x .035W
-----	----------------	--------------------------



Comment: Qty.: 1.2502 f(s)/Unit Total : 25.0040 f(s)
 304 RD Tube .500 x .035W

M107967

EB 08/05

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Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012
(Note: Make (2) D2332-11 Prop Arms per assembly.)

83 08/05/20

20

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. (Drill 1 per assembly)
2-ensure no foreign objects inside fo tube and deburr

08/05/22

(20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

So 08/05/22 (+20) (+20) (+20) (+20)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly) *****
insure nothing is inside of tube before welding*****

50x

A/R SS Rod Batch: M107051

08-06-2. 2

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/08/02/06 (20)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

So 08/06/02 (+20)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

08/06/02 (20)

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Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN4-4A

Bolt

M106918

CP 08/06/03

13.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN960JD416L

Washer

M107008

CP 08/06/03

14.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS21042L4

Nut (or -4)

M107478

CP 08/06/03

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/03 (20)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P 08/06/03 (20)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/03

Job Completion

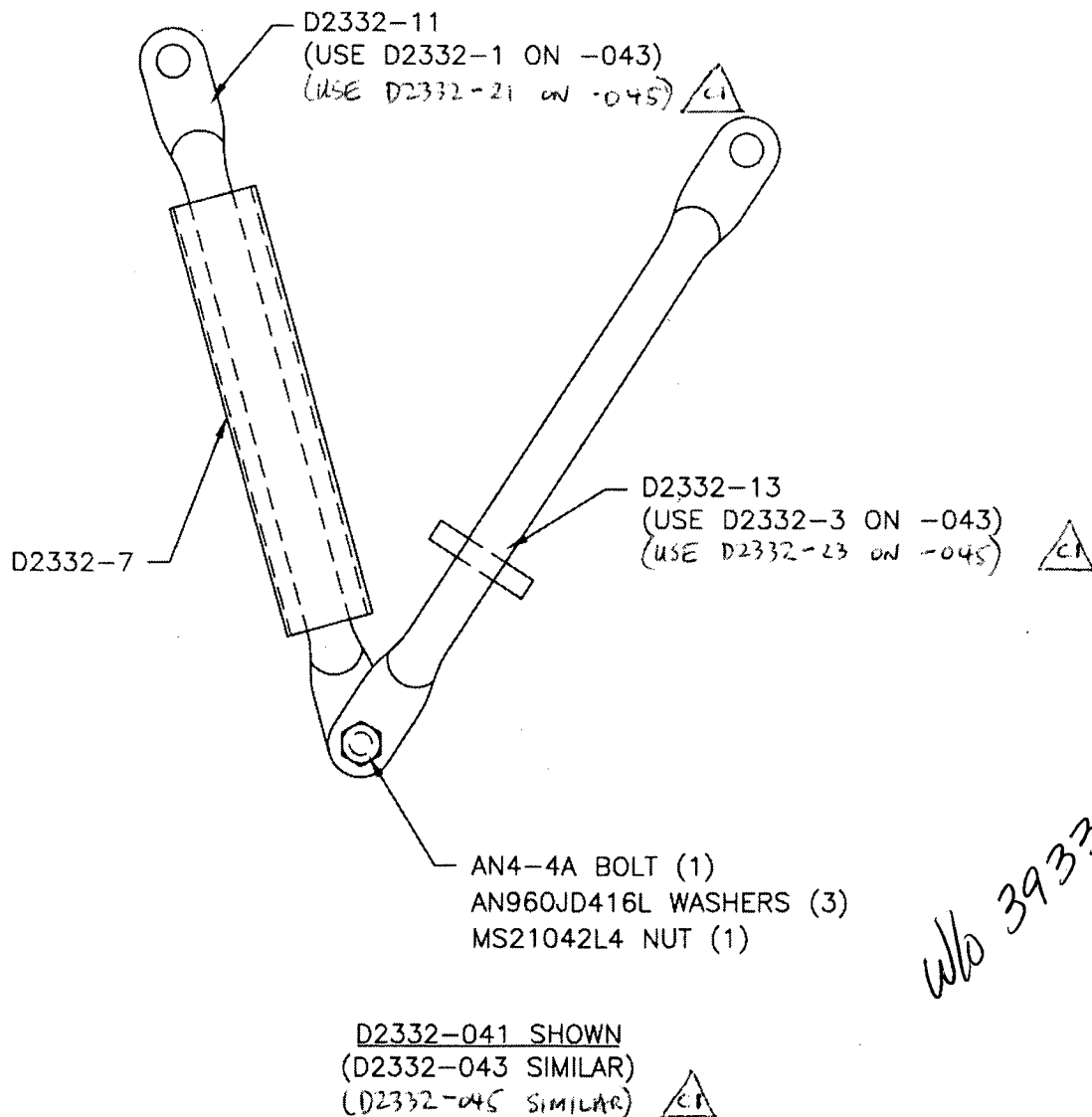


U 08-06-03



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	<i>[Signature]</i> 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04 *[Signature]*



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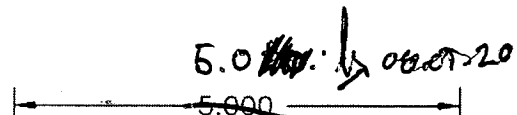
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DART

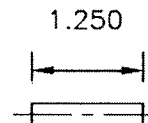
QA CONTROLLED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

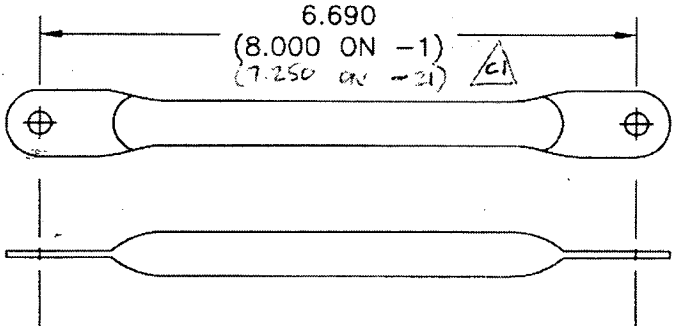
DESIGN	DRAWN BY	TITLE	REV. C
C	03.07.03	MATE -0.01 PROP 6.6" LONG (50)	
C1	03.08.06	MATE -0.03 PROP 8.0" LONG (50)	
		ADD -0.05 PROP (7.25" LONG)	
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 2
		D2332	
DATE		LID PROP ASSEMBLY	SCALE
03.07.03			1:2



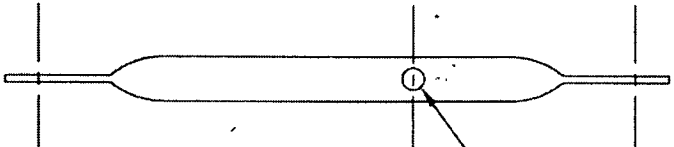
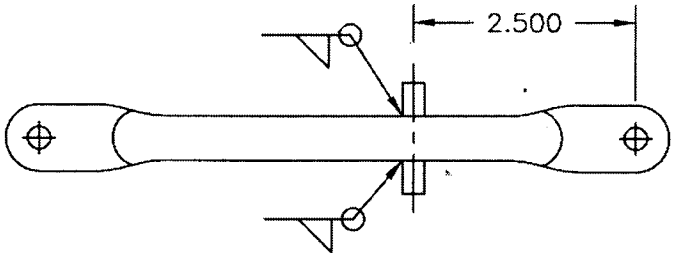
D2332-7 LOCKING COLLAR



D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13
M/F D2332-11 & D2332-5

{D2332-3 SIMILAR - M/F D2332-1 & D2332-5}
{D2332-23 SIMILAR - M/F D2332-21 & D2332-5}

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13